AXMINSTER TOOL CENTRE

CSC500K Key Operated Woodturning Chuck Set

210307

User Manual

Axminster Reference No: **CSC500K**

www.axminster.co.uk

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Warranty...

Thank you for purchasing one of Axminster's growing family of woodworking products. The CSC500K Chuck Set is engineered and manufactured to the highest quality standards. You will find this product an essential accessory to your workshop.

This product is warranted against defects in material and workmanship for a period of one years for all components. This warranty applies to the original purchaser of the product and is limited to the repair and/or replacement of the product, or its parts at the discretion of Axminster Power Tool Centre. Excluded are parts which have been misused, abused, altered, or consumed by normal operation of the chuck. Also excluded are direct or consequential damages to persons, or properties, or materials is as proof of purchase and must be referenced to authorize any warranty repair. Call your Axminster dealer for proper authorization.

SAFETY!! **The symbols shown on the cover of this manual advise that you wear the correct safety protection when using this machine.**

Safety Protection Symbols

www.axminster.co.uk

Safety Instructions for Chuck Systems...

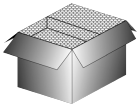
Good Working Practices/Safety

The following suggestions will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.

WARNING!! **KEEP TOOLS AND EQUIPMENT OUT OF THE REACH OF YOUNG CHILDREN**

1. Do not wear gloves or loose clothing when turning.
2. Do not wrap any strip sandpaper or clothing around your hands or fingers when sanding or turning.
3. Use proper eye protection when turning.
4. Check your wood for splits, weakness or cracking prior to mounting on the chuck.
5. Confirm that the wood is tightly gripped before turning your chuck under power.
6. Rotate the chuck manually prior to starting your lathe to confirm proper clearance.
7. Always check and re-lighten after any problem or catch.
8. Use appropriate speeds as referenced in instructions.
9. Always turn with sharp lathe chisels.
10. Capture fine particles from the air with a dust collector.
11. Keep clean and lubricate with a light coat of oil.

What's in the Box...



Model Number: **(210307) CSC500K**

A CSC500K 65mm Barracuda chuck (pre-threaded for 1" x 8tpi)

B 1 Set (4 pieces) gripper jaws (shipped pre-mounted to chuck)

C 1. Hex wrench

D 1 Tightening Key

E 1 Set(4 piece) extended pin jaws

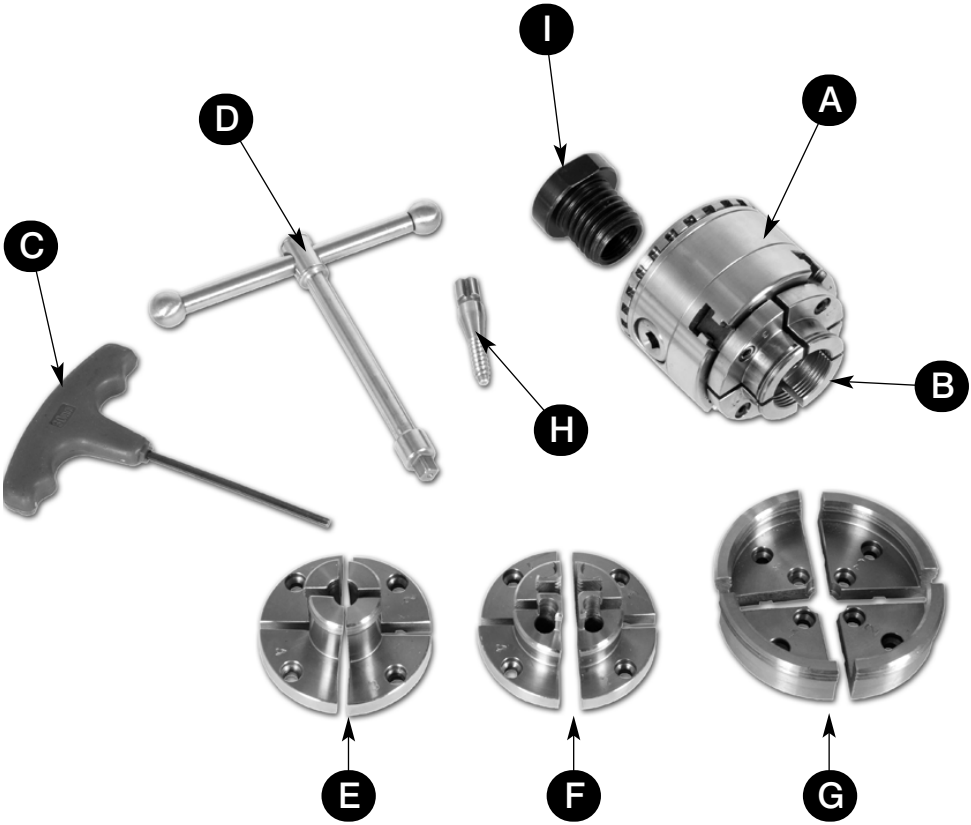
F 1 Set (4 piece) step jaws

G 1 Set (4 piece) internal & external gripper jaws

H 1 Screw chuck

H 1 3/4" x 16tpi adaptor

Instruction Manual


I
A
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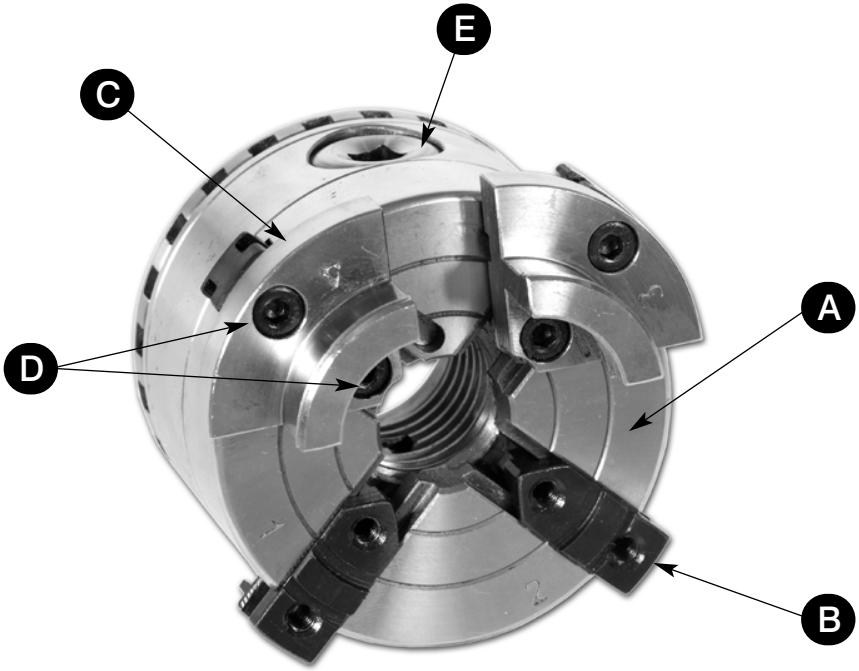
A. Main body: designed to hold all jaws as an assembly.

B. Carrier: to which the top jaws are each attached with one or two hex screws. (the jaws has a tongue which must mate with grooves)

C.Jaws: attached to the carrier, used for gripping the wood piece to be turned.

D. Socket hex screws: attach jaws to chuck (2 per jaw/1 per pin jaw).

E. Tightening holes: insert and turn the tightening key to secure grip.



(Shown with two round jaws installed)

Jaw Capacity Chart...

Jaws Style	Gripping Dowel Outside Diameter	Gripping in Hole Inside Diameter
B 1 Set (4 pieces) gripper jaws	7/8" to 1-1/2"	1-3/8" to 2"
E 1 Set(4 piece) extended pin jaws	1/4" to 1"	7/8" to 1-5/8"
F 1 Set (4 piece) step jaws	1/16" to 13/16"	Step 1: 5/8" to 1-5/16" Step 2: 1-3/16" to 1-7/8"
G 1 Set (4 piece) Internal & external gripper jaws	2-1/4" to 2-7/8"	2-5/8" to 3-1/4"

Installing Jaws to Chuck...

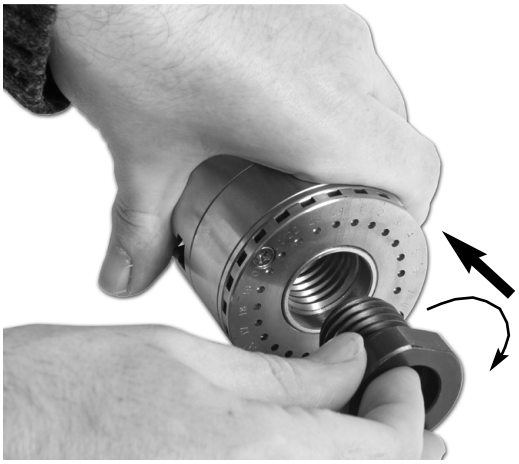
Select the appropriate jaw for your project. Place the selected jaw on top of the carrier, matching the number stamped on the main body to the number on each individual jaw. Using the provided hex wrench, firmly tighten the jaw down onto the surface of the carrier with the hex screws. Repeat this step for the remaining three jaws.

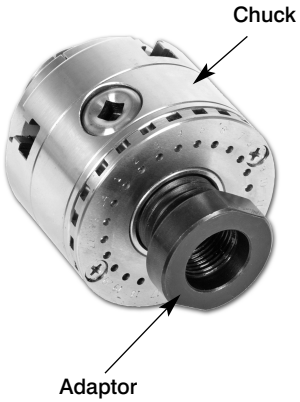
Mounting the Adaptor...

1. Wipe the inside of the threads and the outside of the adaptor to insure both surfaces are clean.

2. Use the furnished 3/4" x l6tpi adaptor if necessary.

3. Hold the chuck in your hand, screw and tighten the adaptor into the bottom threaded portion of the chuck.





Mounting the Chuck to Your Lathe...

Screw the completed assembly onto your lathe. The chuck should go on effortlessly with no binding. Screw the chuck all the way until the adaptor face contacts the shoulder of the lathe spindle. Lock the spindle, slightly unscrew the chuck and give it a firm spin. This will snap the chuck firmly in place.

Operating the Chuck...

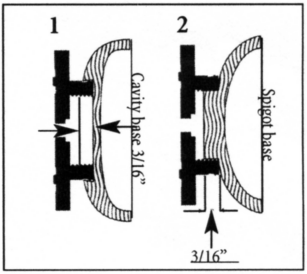
The tightening key aligns with a pivot hole inside your chuck. The tightening key has gear teeth which index with the scroll mechanism inside the micro key chuck. Clockwise tightens, counter-clockwise loosens the jaws.

Chuck Gripping Depth...

When turning a bowl, for safety reasons, allow a minimum amount of wood for the chuck to grab while turning.

1. Cavity base (inside grip) - for a 2" diameter base, minimum hole depth is 3/16".

2. Spigot base (outside grip) - for a 2" diameter base minimum grip is 3/16".



Lathe Speeds...

Turning: 500-l500rpm
Sanding & Polishing: 1500-2500rpm
Make sure your wood is properly aligned and balanced when mounted or re-mounted.
Use slower speeds for larger work.

Maintenance...

Brushing is all that is needed to clean your chuck. If the chuck becomes sticky, clean with **"Dry PTFE Spray Part No: 810135"** or **"Camellia Oil Part No: 510018"**.

DO NOT allow wood chips to become compacted in the teeth of the gear mechanism.

CAUTION: Gear mechanism should be cleaned in between uses. Excessively dirty gear teeth may lead to mechanical failure.

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